

Work Order ID 89284

89284

Page 1

August-24-12 12:49:59 PM

Item ID: D3296-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door Panel
 Start Date: 8/27/12 Start Qty: 10.00 *10*
 Required Date: 8/27/12 Req'd Qty: 10.00 *10*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 12/08/27 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3296 | Rev A | | | | | (16) | | | |

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3296 Dwg Rev: A Prog Rev: A 2-
2024 063 Deburr if necessary B12-9-5

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control B12-9-8

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control Smb 12-9-5 K6

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August-24-12 12:49:59 PM

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 Revision ID: Stop *NS2*
 Item Name: Door Panel

Start Date: 8/27/12 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 8/27/12 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Small Fab | Small Fab | 0.00 | | | | | | | |
| Small Fab | Memo Debur | 0.00 | | | | | | | |
| 140 *140* HandFinish | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| Hand Finishing | Memo | 0.00 | | | | | | | 16x 129.86 |
| 150 *150* QC | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | 16x 129.86 |

Work Order ID 89284

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August-24-12 12:49:59 PM

Item ID: D3296-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Panel

Start Date: 8/27/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/27/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | Identify as per dwg & Stock Location <i>233</i> | 0.00 | | | | <i>16</i> | <i>2</i> | <i>SL</i> | <i>12/9/06</i> |
| *160* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | <i>12/9/11</i> |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

ME
12-09-07

Picklist Print

August-24-12 12:49:59 PM

Page 1

Work Order ID: 89284

Parent Item: D3296-1

Parent Item Name: Door Panel

Start Date: 8/27/12

Required Date: 8/27/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Now on Waterjet 06-11-02 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.063 2024-T3 .063 sheet | | Purchased | No | | | 100 | sf | 136.5200 | 0.6596 | 6.943158 | 7 | 8-12-9-8 | |

Location

Loc Qty

Loc Code

MAT022

136.52

119916

67.1

121197

69.42

121197



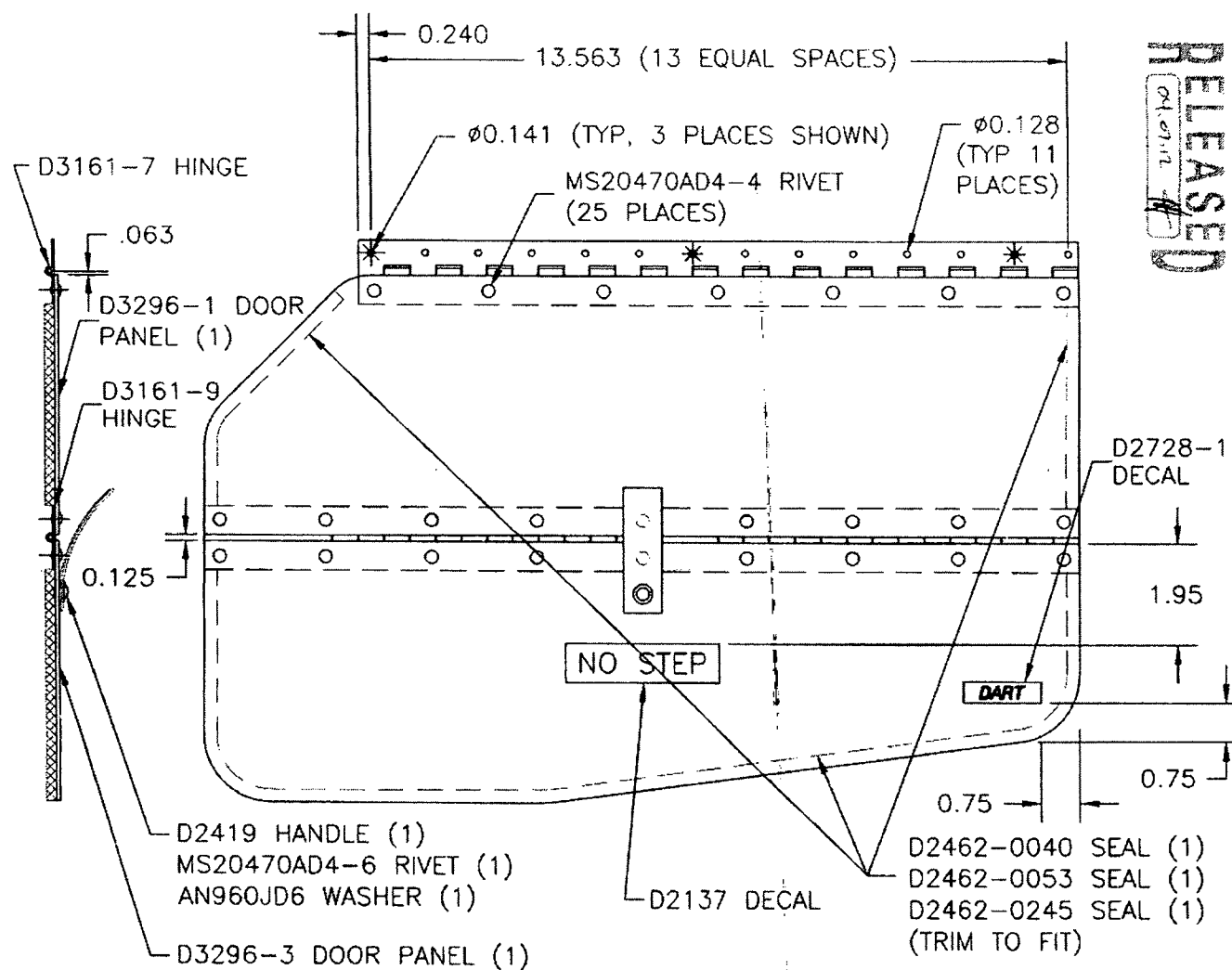
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT: DART
WARRANTMENT
W NOTICE
W ORDER
NO. 89284
MLJ
12/08/27



RELEASED
04.07.12

| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|----------------------------|-----------------------------|---|
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3296 |
| DATE 04.06.28 | TITLE DOOR ASSEMBLY | REV. A 1 OF 2 SCALE 1:3 |
| A | 04.06.28 | NEW ISSUE |



D3296-041 DOOR ASSEMBLY

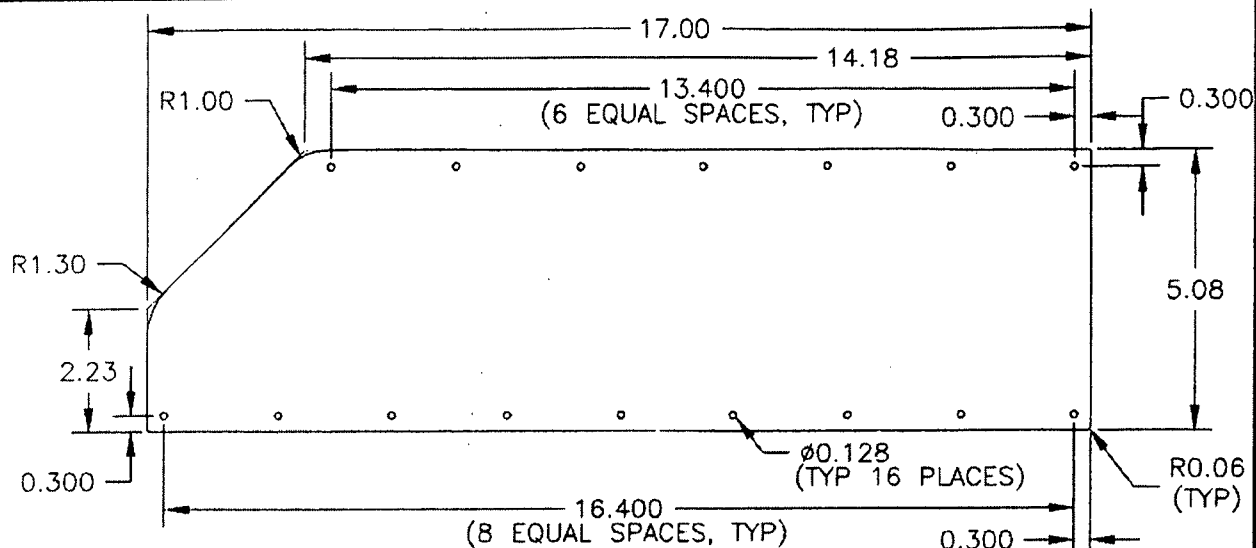
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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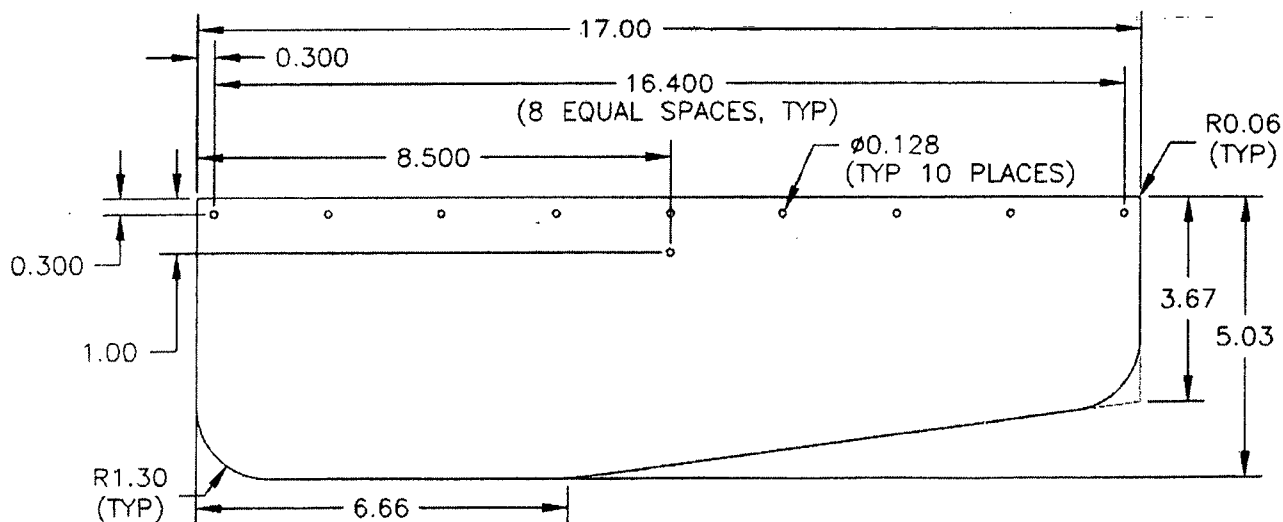
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| | | | |
|------------------------|-------------------------|---|------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3296 | REV. A 2 OF 2 |
| DATE 04.06.28 | TITLE DOOR ASSEMBLY | | SCALE 1:3 |



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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89284

Receiving Report

Date: 12/3/29

Batch No: M121197

Supplier: 74200.17

Dart P/O: 16520

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☐ No ☒ N/A ☐
 QC6 Inspection S210317 N/A ☒
 Work Order S210317 N/A ☐

| Discrepancies | | | | | | |
|---------------|-------------|------------------|-------------------|-------------------|----------------|----------|
| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
| M1243.2008400 | | 12 | 0 | 0 | 12 | |
| | | | | | | |
| | | | | | | |

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 12/3/29
 Date [Signature]
 Received/Costing [Signature]
 Initial [Signature]

Location _____

B I L L O F L A D I N G

Ship From:
 THYSSENKRUPP MATERIALS NA
 2821 LANGSTAFF ROAD
 CONCORD, ONTARIO L4K 5C6
 Tel: 905 669 9444 Fax: 9057389033

No: PEC 759943
 Ship Date 29Mar12 at 16:28 From PFW
 Probill
 Via VIM TRANSFER
 FOB CONCORD
 Frt PREPAID
 Route 0- 0 Manifest
 Vhcle Trailer
 Slp STAN IVERS (905-532-1350)
 Sold To: (20115)
 DART AEROSPACE
 1270 ABERDEEN ST
 HAWKESBURY, ON K6A 1K7

Ship To: (1)
 DART AEROSPACE
 1270 ABERDEEN ST
 HAWKESBURY, ON K6A 1K7
 Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G

1) Our Order PEC-432770- 1 Your PO # 16520
 ALUMINUM SHEET 2024 -T3

MTR

.0640 Nom X 48.0000" X 144.0000"

Heat Number Tag No
 110855 520769

Quantity PCS Wt LBS
 96.00 SFT 2 / 55

2) Our Order PEC-432770- 2 Your PO # 16520
 ALUMINUM SHEET 2024 -T3

.0640 Nom X 48.0000" X 144.0000"

Heat Number Tag No
 558264A8 520770

Quantity PCS Wt LBS
 240.00 SFT 5 / 218

MTR

TOTAL:

Tags PCS LI
 2 7 273

ADD ON TO 432765 SUR-CHARGE PAID

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
 WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
 TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
 ** REFERENCED ON IT **

TOTAL (1,2) 1 SKID GW. 393 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
 CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
 RAPPORTÉES IMMÉDIATEMENT.
 ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
 RETOUR DE MARCHANDISE AVEC NOTRE NUMERO D'APPROBATION SEULEMENT
 MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

B I L L O F L A D I N G

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

No: PEC 759943
Ship Date 29Mar12 at 16:28 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

Ship To: (1)
DART AEROSPACE

B I L L O F L A D I N G

***** TEL. 800-926-2600 *****

* WE STOCK STAINLESS STEEL *
* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE
ADDED TO EVERY ORDER.***

Page: 2 Last

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

2

| |
|--|
| SHIP TO: Charleston Aluminum LLC 480 Frontage Rd Gaston, SC 29053 |
| SOLD TO: |

**KAISER
ALUMINUM**
Trentwood Works - Spokane, WA 99215

CERTIFIED TEST REPORT

Serial Number
4240572

C & B MATERIAL #: ALFLR 01583

| | | | | | | |
|----------------------------------|--------------------------|---------------------------|-----------------------------|------------------------------|-----------------------|---------------------------------------|
| CUSTOMER PO NUMBER: KS-533198 | WORK PACKAGE: | CUSTOMER PART NUMBER: | SHIP RUN/LOAD: 102148/11 | GOV'T CONTRACT NUMBER: | | |
| KAISER ORDER NO: 1125518 | LINE ITEM: 1 | SHIP DATE: 30-SEP-2011 | ALLOY: 2024 | CLAD: BARE | TEMPER: T3 | PRODUCT DESCRIPTION: HT Flat Sheet |
| WEIGHT SHIPPED: 3012 LB | QUANTITY: 67 PCS EST. | B/L NUMBER: 2033920 | GAGE: 0.0830 IN | DIAMETER/WIDTH: 48.000 IN | LENGTH: 144.000 IN | |

MHU 1523931: LOT 558264A8: 67 pieces;

Certified Specifications

AMS 4037/RevN
CMMP 019/RevD

AMS-QQ-A-250/4/RevA
CMMP 025/RevT

ASTM B 209/Rev07

Test Code: 1504

Test Results

Lot: 558264A8 Cast 544

Drop 28

Ingot 2

Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile: Temper
T3

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPA)
66.7 : 67.1
(460 : 463)

Yield KSI (MPA)
44.2 : 44.5
(305 : 307)

Elongation %
19.1 : 19.5

(ASTM E1251)
Chemistry:
Actual

| | | | | | | |
|------|------|-----|------|-----|------|------|
| SI | FE | CU | MN | MG | CR | ZN |
| 0.10 | 0.25 | 4.5 | 0.56 | 1.3 | 0.01 | 0.09 |

| | | | |
|------|------|------|----------|
| TI | V | ZR | OTHER |
| 0.02 | 0.02 | 0.01 | TOT 0.04 |

ALLOY LIMITS

| | | | | | | | |
|------|------|------|-----|------|-----|------|------|
| | SI | FE | CU | MN | MG | CR | ZN |
| 2024 | | | | | | | |
| MIN | 0.00 | 0.00 | 3.8 | 0.30 | 1.2 | 0.00 | 0.00 |
| MAX | 0.50 | 0.50 | 4.9 | 0.9 | 1.8 | 0.10 | 0.25 |

Aluminum Remainder

| | | | | |
|------|------|------|-------|------|
| TI | V | ZR | OTHER | MAX |
| 0.00 | 0.00 | 0.00 | EACH | 0.15 |
| 0.15 | 0.05 | 0.05 | TOT | 0.15 |



Page 1 of 2

From: Copper and Brass Sales

Cust: THYSSENKRUPP MATERIALS NA - ECAD Del: 2401766927

Part:

PO: PEC - 237828

Wgt: 217.728 LB

Date: 03/22/2012

James K Baber

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215

CERTIFIED TEST REPORT

Serial Number
4240572



CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.872-1(a), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 262.226 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED.

MIKE KLOCKE, LABORATORIES SUPERVISOR

Page 2 of 2

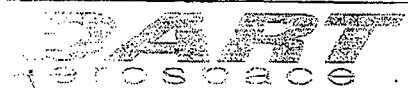
From: Copper and Brass Sales

Cust: THYSSENKRUPP MATERIALS NA - ECAD Del: 2401766927

Part: PO: PEC - 237828

Wgt: 217.728 LB

Date: 03/22/2012



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16520

Purchase Order Date 3/21/12

PO Print Date 3/22/12

Page Number 1 of 2

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
C/O VPK METAL- C/O T27540/PO BOX 4275.POSTAL "A"
TORONTO, ON M5W 5V8
CA

Contact Name

Vendor Phone 905 669 9444

Vendor Fax 905 738 9033

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED

\$ 100.00

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|---|--|-------------------------|----------------------|-----------------------------|-------------|------------|-------------------|
| 1 | M174B0.250X4.000 | 17-4 SS Bar .250 X 4.00 | 3/30/12 Yes | 12.00 sf | Yours ppd | \$48.7500 | |
| Special Inst: MATERIAL: 17-4 PH SS BAR AS PER AMS 5604/6543 GRAIN MUST BE ALONG LENGTH OF BAR | | | | | | | |
| 2 | M2024T3S.040 | 2024-T3 .040 sheet | 3/30/12 Yes | 96.00 sf | Yours ppd | \$3.6458 | \$350.00 |
| Special Inst: MATERIAL: 2024-T3 ALUMINUM SHEET QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 | | | | | | | |
| 3 | M2024T3S.063 | 2024-T3 .063 sheet | 3/30/12 Yes | 240.00 sf | Yours ppd | \$5.5208 | \$1,325.00 |
| Special Inst: MATERIAL: 2024-T3 ALUMINUM SHEET QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 | | | | | | | |

No substitution or deviation witho
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 3/22/12